

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023841**Date Inspected:** 17-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Tian Lei, Liu Fa Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 3

SMAW welding of complete join penetration welds located on Edge Plate component identified as EP3018-001 for weld no. 005 & 008. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2213-B-U2.

SMAW welding of complete join penetration welds located on Side Plate component identified as SP3081B-001 for weld no. 036, 045, & 035. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2213-TC-U4b.

This inspector observed ZPMC QC personnel performing MT testing and inspection on the following components: 20TR-3 weld no.(s) 009, 011, 013, & 015.

Bay Number 8

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 08199. The member(s) is/are identified as OBG Bike Path identified as components BK004A3 & A5-064 with the following weld no.(s):

1. BK004A3-063-002, 003, 007, & 010..
2. BK004A5-063-002, 003, 006, & 008.

FCAW welding of complete joint penetration welds located on Bike Path component identified as BK004A-059 for weld no. 002, 008, 013, & 021. Welder is identified as welder no. 500405. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

SMAW welding of complete joint penetration welds located on Bike Path component identified as BK004A6-059 for weld no.(s) 014, 015, 017, 019, & 020. Welder is identified as welder no. 066155. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-P-2112-PLUG.



Summary of Conversations:

Pertinent conversations are included in the body of the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
